

Date: Thursday, 6/15/2006 1:42:34 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : WASHER
 Job Number : 27571
 Estimate Number : 11218
 P.O. Number : N/A Part Number : D34173
 This Issue : 6/15/2006 S.O. No. : N/A Drawing Number : D3417 REV C
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : C
 Previous Run : 25119 Material : N/A
 Written By : SEALY COMMENT BELOW Due Date : 7/2/2006 Qty: 35 40 0m Each
 Checked & Approved By : 06/06/25
 Comment : Est Rev: A 05.10.19 New issue KJ/EC
 Est Rev: B 05.10.19 added haas op. EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 MDLRINR12500 DELRIN ROUND BAR 1.25"



Comment: Qty.: 0.0311 f(s)/Unit Total : 0.3108 f(s)
 Material: Delrin Round Bar Ø1.250
 (M-DELRIN-R1.250)
 Batch: M101078
 Identify for D3417-3 16"

M8 06/06/25

2.0 HARDINGE HARDINGE CNC LATHE SMALL



Comment: HARDINGE CNC LATHE SMALL

1-Turn as per Folio FA594 Rev: C & Dwg D3417 Rev: C

2-Deburr

M8 06/06/25

35

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

M8 06/06/25

35

4.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

-Machine as per folio FA594 rev. C & dwg D3417 rev. C

J.F. 06/06/28

30

5.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE


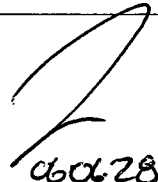





Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 06/06/28

30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06/06/28	4	5 parts came off the tape in the Hous. 5 parts scrap.		Scrap = destroy. No replace.	J.F. 06/06/28	 06-06-28	 06-06-28	 06-06-28

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA:  Date: 06/06/29

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WASHER

Job Number: 27571

Part Number: D34173

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SA 66.06-28

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

AL 06/06/28

(30)

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

D 06/06/29

(30)

Job Completion



u 26.06.28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector



NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			


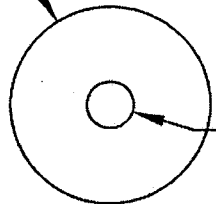
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART

DESIGN PH	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED 	APPROVED 	DRAWING NO. D3417	REV. C SHEET 1 OF 1
DATE 05.06.30		TITLE WASHER	SCALE 1:1
A	05.03.31	NEW ISSUE	
B	05.06.10	CHANGE TO ROUND WASHER	
C	05.06.30	REMOVE C'BORE, WIDEN	

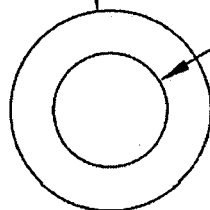
RELEASED05.11.14  $\varnothing 1.125^{+0.030}_{-0.000}$  $\varnothing 0.265^{+0.005}_{-0.000}$

R1.87

0.409



0.320

 $\varnothing 1.125^{+0.030}_{-0.000}$  $\varnothing 0.640^{+0.005}_{-0.000}$

R1.87

0.346



0.260

**D3417-1 WASHER****D3417-3 WASHER****D3417-1/-3 WASHER**

- 1) MATERIAL: DELRIN (REF. DART SPEC. M-DELRIN-R1.250)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 2759-1

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